



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10400-041-63-PO
Job Sheet 185658



Part No: RB 92700-10400-041-63-PO **Job Qty:** 3 ea

Part Name: Cyclic - Rig Block Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10400-041 Rev.A. IPP Rev. A 18.10.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs	12/14/18	12/14/18	0.00	0.00	Purchasing		DEC 20 2018
110	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		DEC 20 2018
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC6		DEC 21 2018
130	Small Fab	3 pcs	12/14/18	12/14/18	0.00	0.30	Small Fab-2		9-89
140	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC5		18
150	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3		70
160	QC21-SA	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DEC 27 2018

Part Op 100 - Issue P/O: 041341 MANUFACTURE RB 92700-10400-041-63 AS PER DWG Supplier: ARROW TECH
Descriptions: MACHINE WORKS -Certificate of conformity is required
130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10400-041-63P	Cyclic - Rig Block Assembly	3 (1 ea)	100-Purchasing	5139742

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10400-041-63P	3	0	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Id not be found.

Plex 10/31/18 9:39 AM dart.Lussier.Patrick

Container No: S139743



Part: RB 92700-10400-041-63

Job No: 185658

Serial No/Batch: S139743

Revision: A

Inspector:

Exp Date:

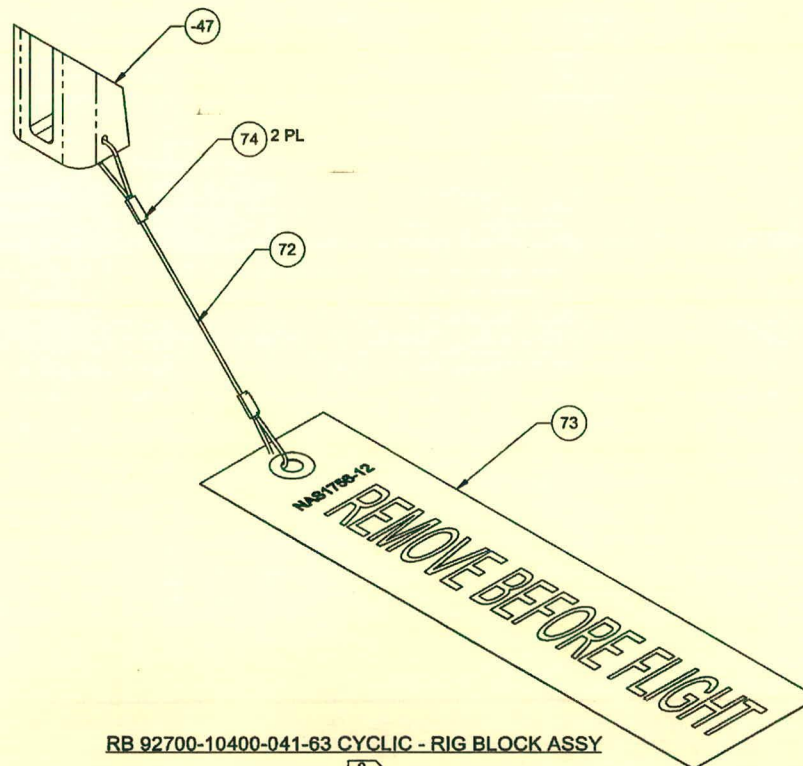
Instructions:

Date: 12/21/18

4-80
NO
DEC 5 1980
DEC 5 1980

DEC 5 1980
DEC 5 1980

ITEM #	QTY	PART #	PART TITLE
-47	1	RB 92700-10400-041-47	BLOCK
72	1	CARR LANE #CL-2-C	LANYARD 6" LONG
73	1	NAS 1756-12	FLAG
74	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.



RB 92700-10400-041-63 CYCLIC - RIG BLOCK ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: N/A

- 7) IDENTIFICATION: N/A

- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10400-041	SHEET 59 OF 62
APPROVED	VM	TITLE	SCALE
DATE 9/19/2018		RIGGING KIT	NTS
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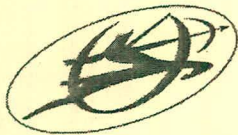
PURCHASE ORDER **PO041341**

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
38	185649	RB 92700-10400-041-33P			Boost Col Low REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
39	185650	RB 92700-10400-041-36P			3.5" Pin Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
40	185651	RB 92700-10400-041-39P			9" Pin Assembly REV A	Firmed	-	12/21/18	6 Ea	0 Ea	6 Ea	\$213.84/Ea	\$1,283.04
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
41	185652	RB 92700-10400-041-41P			16" Pin Assembly REV A	Firmed	-	12/21/18	6 Ea	0 Ea	6 Ea	\$213.84/Ea	\$1,283.04
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
42	185654	RB 92700-10400-041-43P			Cockpit - Rig Pins REV A	Firmed	-	12/21/18	15 Ea	0 Ea	15 Ea	\$213.84/Ea	\$3,207.60
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
43	185655	RB 92700-10400-041-45P			5" Pin Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
44	185656	RB 92700-10400-041-49P			Boost Mid Pin REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
45	185657	RB 92700-10400-041-52P			Rotor Head - Cross Bar REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
46	185658	RB 92700-10400-041-63P			Cyclic - Rig Block Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52

3X

DEC 20 2018

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**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 1 OF 2

Date: 12/14/2018 ✓
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	SEAL INSTALLATION TOOL	RB 92700-10300-041 - 1
3 ✓	PLATE ASSEMBLY	RB 92700-10303-041 - 4
3 ✓	WRENCH ASSEMBLY	RB 92700-10303-041 - 6
3 ✓	TGB & IGB SEAL INSTALLER ASSEMBLY	RB 92700-10305-041 - 4
2 ✓	TR NUT WRENCH	RB 92700-10307-041 ✓
3 ✓	TAIL BLADE WRENCH (DE-ICE) WELDMENT	RB 92700-10309-042 ✓
3 ✓	TORQUE REACTOR	RB 92700-10314-101 ✓
3 ✓	SIGHT GUAGE REMOVAL TOOL	RB 92700-10328-041 ✓
3 ✓	ENGINE DRIVE SHAFT REMOVAL TOOL ASS	RB 92700-10333-041 ✓
3 ✓	BEARING SPANNER WRENCH	RB 92700-10340-101 ✓
3 ✓	SEAL REMOVAL ASSEMBLY	RB 92700-10350-041 - 5
3 ✓	BEARING ALIGNMENT TOOL	RB 92700-10356-041 ✓
3 ✓	TORQUE ADAPTER	RB 92700-10750-101 ✓
3 ✓	INPUT MODULE WRENCH	RB 92700-10750-102 ✓
3 ✓	RIG PLATE SCREW	RB 92700-10400-041-6 ✓
3 ✓	PIT STOP GUAGE	RB 92700-10400-041-7 ✓
3 ✓	RIG GUAGE PLATE (SPARES)	RB 92700-10400-041-9 ✓

Received by: _____
Packaged by: _____
Checked by: _____

Thank You



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Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3	TRS LEFT STOP GUAGE	RB 92700-10400-041-11
3	RH MID GUAGE	RB 92700-10400-041-12
3	TR MID BLOCK	RB 92700-10400-041-13
3	ROLL STOP GUAGE	RB 92700-10400-041-14
3	COLL STOP GUAGE	RB 92700-10400-041-16
3	LIMITER GUAGE	RB 92700-10400-041-18
3	LH MID GUAGE	RB 92700-10400-041-20
3	FWD MID GUAGE	RB 92700-10400-041-22
3	RH MID GUAGE	RB 92700-10400-041-24
3	MIX PIN P / C / R	RB 92700-10400-041-26
3	MIX PIN YAW	RB 92700-10400-041-28
153	RIG PIN ASSEMBLY	RB 92700-10400-041-30
3	BOOST COL LOW	RB 92700-10400-041-33
3	3.5" PIN ASSEMBLY	RB 92700-10400-041-36
3	9" PIN ASSEMBLY	RB 92700-10400-041-39
3	16" PIN ASSEMBLY	RB 92700-10400-041-41
3	COCKPIT - RIG PINS <i>Missing CFC</i>	RB 92700-10400-041-43

Received by:

Packaged by: *ADD*

Checked by: *Q.F.*

Thank You



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CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	5" PIN ASSEMBLY	RB 92700-10400-041-45 ✓
3 12 ✓	BOOST MID PIN	RB 92700-10400-041-49 ✓
3 ✓	ROTOR HEAD - CROSS BAR	RB 92700-10400-041-52 ✓
3 ✓	CYCLIC - RIG BLOCK ASSEMBLY	RB 92700-10400-041-63 ✓
3 ✓	ROTOR HEAD - RIG PLATE	RB 92700-10400-041-64 ✓

Received by: _____

Packaged by: HR

Checked by: Q.E.

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041341 ✓ Dated: 12/14/2018

Our Order / Job No: 041341-46AWT Order Qty: 3 ✓

Part Name: CYCLIC – RIG BLOCK ASSEMBLY

Part Number: RB 92700-10400-041-63 ✓

Lot Size: N/A Ship Date: 12/14/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB 92700-10400-041-63 Rev: A

Material Size and Type: -47/ 6061-T6 ALUM.

Material Specifications: ALUM: ASTM B209

Heat Treatment: N/A

Plating/Finish: RED ANODIZE: MIL-A-8625 TYPE CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/17/18

Signed: 

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PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>185658</u> Part No. <u>RB92700-10400-041-63</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☒ Engineering Quality ☐ Other ☐				
Date: <u>DEC 21 2018</u>		Step #: <u>110</u>		QTY Effective: _____		MRB (QSI042) Approval DAS 9 9-89 DEC 21 2018		
Description Work Order Deviation - PART NOT ASSEMBLED BY SUPPLIER. LANYARD MISSING (ITEM 72)				Disposition - ASSEMBLE IN-HOUSE WITH #CL-2-C X 6.5" OF LANYARD EACH, <u>5093863</u>				Completed By <u>MCC</u>
				Lead hand / Supervisor Approval Verification				
				QC / QA Coordinator Approval				
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☒ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
☒ OTHER: <u>LANYARD NOT AVAILABLE.</u>								

